

40

Date: Wednesday, 9/12/2007 12:06:18 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FLOAT STEP
 Job Number : 34576
 Estimate Number : 10850
 P.O. Number :
 This Issue : 9/12/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 33922
 Part Number : D206628024
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : N/A
 Material :
 Due Date : 9/30/2007 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : 07.09.12
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-024 CHG 002

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 34576A FLOAT STEP ASSEMBLY RH (206/407)



Comment: Sub-Component FLOAT STEP ASSEMBLY LH (206/407)

D2842-042 B 34576A

4.0 D27317 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 Mounting Lug B33420

5.0 D28441 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2844-1 Arm B334000 (31)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:06:18 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 34576

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2844-3

Arm

B34001

7.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2660 f(s)/Unit Total: 5.0639 f(s)

Pick:

Qty Part #

Description

Batch

2 D2856-400 6.9" Abrasion Strip

B34293

8.0

D3394043

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D3394-043 LUG ASS,Y

B33225

9.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C4A

Bolt

M105143

10.0

AN4C12A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C12A

Bolt

M105426

11.0

AN4C13A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C13A

Bolt

M105289

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:06:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 34576

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M103915-

13.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total : 12.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10

WASHER

M101064-

14.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L Washer

M105408-

15.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L Washer

M105408-

16.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21043-4 Nut (or MS21042-4)

M105115-

17.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 NAS1515H3 Washer

M105164-

Ep 07/09/25 (4)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:06:18 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 34576

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

En 8/10/07

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-024

Location:

PPP Rev:

E

7/10/07 SP (4x)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.01

Job Completion



in 8/10.01

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Tuesday, 05/02/2008 3:12:54 PM,
User: Dominique Dube

Process Sheet

| | |
|--|--|
| Customer : CC-DAR01 Dart Aerospace Ltd. | Drawing Name : D206-628-024 |
| Job Number : 37229 | |
| Estimate Number : 10804 | |
| P.O. Number : | Part Number : D206628024 |
| This Issue : 05/02/2008 S.O. No. : | Drawing Number : ECN 1118 |
| Prsht Rev. : NC | Project Number : |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : |
| Previous Run : 37228 | Material : |
| Written By : <u> </u> | Due Date : 12/02/2008 Qty: 5 Um: Each |
| Checked & Approved By : <u> </u> | |
| Comment : | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------------|-----------------------|
| 1.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
PULL FROM STOCK

D206-628-024 CHG002 1x B33759

3x B34576

2- 33922 003

B34576 3x

| | | |
|-----|-------------|-----------------------|
| 2.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
ADD NEW PARTS TO KIT PER ECN 1118

*** NEW RED AND WHITE LABELS REQUIRED FOR
NEW CHANGE NUMBER ***

8x D2732 RUBBER EXTRUSION

CUT 3.00" LONG B

34717

B 34717 A8

4x AN4C14A BOLT B

107087

M107087 A8

4x AN4C15A BOLT B

106785

M107013 A8

8/2/12 50

(5x)

| | | |
|-----|-------|------------------|
| 3.0 | D2732 | Rubber Extrusion |
|-----|-------|------------------|



Comment: Qty.: 20000 f(s)/Unit **Total:** 100000 f(s)
Rubber Extrusion

334717

8/2/12 50

(5x)

Date: Tuesday, 05/02/2008 3:12:54 PM
User: Dominique Dube

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-628-024

Job Number: 37229

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

AN4C14A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

M107087

SD

5.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

M106785

M107013

AS 08/02/02

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2060226

08/02/12

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*** PLEASE ADD A COPY OF THIS WORK ORDER
TO THE ABOVE WORK ORDERS ***

2008/02/05

Job Completion



2008/2/19

Q

Date: Friday, 18/04/2008 7:50:09 AM
 User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|--------------------------------|------------------|------------------------------|
| Customer | : CC-DAR01 Dart Aerospace Ltd. | Drawing Name | : D206-628-UPDATE PAPERWORK |
| Job Number | : 38685 | | |
| Estimate Number | : 10804 | | |
| P.O. Number | : | Part Number | : Z_CUSTOM |
| This Issue | : 18/04/2008 S.O. No. : | Drawing Number | : ECN1126 |
| Prsht Rev. | : NC | Project Number | : |
| First Issue | : 11 Type : LARGE FAB ASSY | Drawing Revision | : |
| Previous Run | : 00015 | Material | : |
| Written By | : | Due Date | : 25/04/2008 Qty: 1 Um: Each |
| Checked & Approved By | : | | |
| Comment | : | | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

| | | | | | | |
|--------------|-------|------|-------|------|-------|------|
| D206-628-011 | 33038 | (3x) | 33411 | (3x) | | |
| D206-628-012 | 33892 | (1x) | 33412 | (1x) | | |
| D206-628-013 | 36963 | (4x) | 36078 | (1x) | | |
| D206-628-014 | 36964 | (6x) | | | | |
| D206-628-021 | 31974 | (1x) | 34980 | (1x) | 35756 | (2x) |
| D206-628-022 | 33757 | (1x) | 34981 | (3x) | | |
| D206-628-023 | 36492 | (1x) | 34575 | (2x) | | |
| D206-628-024 | 36493 | (1x) | 34576 | (3x) | | |
| D206-628-031 | 31010 | (4x) | | | | |
| D206-628-032 | 31011 | (4x) | | | | |
| D206-628-033 | | | | | | |
| D206-628-034 | | | | | | |

ADD NEW PAPERWORK TO KITS IN STOCK
 DSI 9332, PER ECN 1126

8/14/24 500